

Work Order ID 132857

Tuesday, May 12, 2015 2:46:20 PM

132857

Ship May 20th

Page 1

Item ID: D2003-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tube Assembly-8J
 Start Date: 5/12/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/19/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: mf Date: 15-5-12 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2003	C								
100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1-Form tube as per template D2003-043								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Small Fab	0.00							
120									
Small Fab	Memo	0.00							
Small Fab	1-Cut tube as per template D2003-043 and cut heat sleeve as per dwg								
	2 -Assemble as per Dwg D2003								

1 FF MAY 13 2015
 1 38 9-89
 1 FF MAY 13 2015

Work Order ID 132857

Tuesday, May 12, 2015 2:46:20 PM

132857

Page 2

Item ID: D2003-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tube Assembly-8J

Start Date: 5/12/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/19/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u> / </u>			DAS 38 9-89 MAY 13 2015
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>S/208</u> Memo	0.00 0.00				<u> / </u>			DAS 27 9-89 MAY 14 2015
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				<u> MLJ </u>			MAY 14 2015

MLJ MAY 14 2015

Picklist Print

Tuesday, May 12, 2015 2:46:19 PM

Page 1

Work Order ID: 132857

132857

Parent Item: D2003-043

D2003-043

Parent Item Name: Tube Assembly-8J

Start Date: 5/12/2015

Required Date: 5/19/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.11.02 as per revB DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-8J		Purchased		No		100	Each	12.0000	2	2			

AN818-8.J

Nut

FF

MAY 13 2015

Location	Loc Qty	Loc Code
ST325	12	
114365	2	
118179	10	

2

M2650-6

Purchased

No

100

f

51.0000

0.975

2

M2650-6

Firesleeve-Crkl .375Idia

FF

MAY 13 2015

Location	Loc Qty	Loc Code
Mezz	51	
114341	51	

21

M304TR0.500W.035

Purchased

No

100

f

63.6000

0.975

2

M304TR0 500W 0.35

304 RD Tube .500 x .035W

FF

MAY 13 2015

Location	Loc Qty	Loc Code
GA002	63.6	
125513	2	
126922	3.5	
m128084	11	
m128495	31	
m128833	0.07	
m129188	8	
m130292	0.5	
m131717	7.53	

9
2

Picklist Print

Tuesday, May 12, 2015 2:46:19 PM

Page 2

Work Order ID: 132857

132857

Parent Item: D2003-043

D2003-043

Parent Item Name: Tube Assembly-8J

Start Date: 5/12/2015

Required Date: 5/19/2015

Start Qty: 1.00

Required Qty: 1.00

MS20819-8J

Purchased

No

100

Each

9.0000

2

2

MS20819-8.J

Sleeve

FF

MAY 13 2015

Location

Loc Qty

Loc Code

ST307

9

112933

9

2

NOTES:

1) MATERIAL:

1.1) 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, 0.375 OD X 0.035 WALL
PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 OR AMS 4080/4082/4083 OR ASTM B210/B241
REF. DART SPEC. M6061T6T0.375W0.035

OR
5052-OT SEAMLESS ROUND TUBING, 0.375 OD X 0.035 WALL

PER WW-T-700/4 OR ASTM-B-210-02

REF. DART SPEC. M5052-OT0.375W0.035

1.2) 6061-T6/T62/T6510/T6511 SEAMLESS TUBING, 0.500 OD X 0.035 WALL

PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8 OR AMS 4080/4082/4083 OR ASTM B210/B241

REF. DART SPEC. M6061T6T0.500W0.035

OR

5052-OT SEAMLESS ROUND TUBING, 0.500 OD X 0.035 WALL

PER WW-T-700/4 OR ASTM-B-210-02

REF. DART SPEC. M5052-OT0.500W0.035

1.3) AISI 304/316 SS SEAMLESS ROUND TUBING, 0.500 OD X 0.035 WALL

PER ASTM A213 OR ASME SA213 OR ASTM A269

REF. DART SPEC. M304TR0.500W0.035

1.4) HEATSLEEVE: STRATOFLEX M2650-6 CRINKLE-SOFT UNLESS OTHERWISE NOTED

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: PER DART QSI 044 6.1

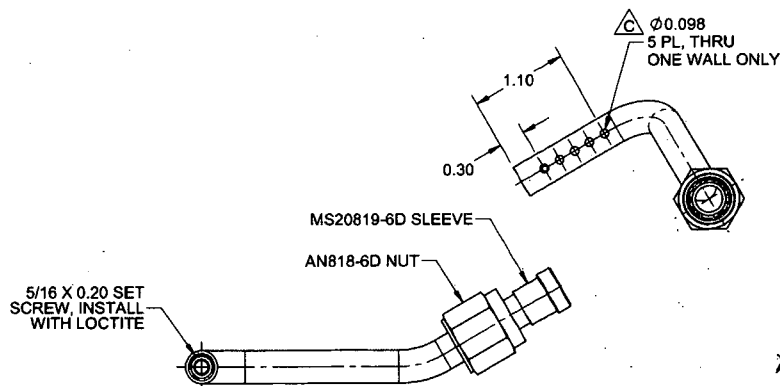
7) WEIGHT: SEE TABLE

8) FORMING: IN ACCORDANCE WITH TEMPLATES

9) FLARING OF TUBING: 30° TO MATE WITH FITTINGS PER MS33514

10) HEATSLEEVE INSTALLATIONS: OVER ALL TUBES WITH DESIGNATED LENGTH PER PARTS LIST

11) IT IS ACCEPTABLE TO SUBSTITUTE 0.035 WALL THICKNESS WITH 0.049 WALL THICKNESS



D2003-077 DETAIL VIEW

P/N	TEMPLATE	HEATSLEEVE LENGTH [1.4]	CUT LENGTH OF TUBE [8]	MS20819-6J SLEEVE	AN818-6J NUT	MS20819-6D SLEEVE	AN818-6D NUT	MS20819-6D SLEEVE	AN818-6D NUT	DESCRIPTION	MATERIAL	WEIGHT (In lbs)
D2003-001	T2003-001	5.2	6.00					2	2	TUBE ASSY	SEE NOTE 1.1	0.06
D2003-003	T2003-003	7.3	8.12					2	2	TUBE ASSY	SEE NOTE 1.1	0.08
D2003-005	T2003-005	9.8	10.62					2	2	TUBE ASSY	SEE NOTE 1.1	0.10
D2003-007	T2003-007	20.0	19.63					2	2	TUBE ASSY	SEE NOTE 1.1	0.16
D2003-009	T2003-009	12.38	12.44					2	2	TUBE ASSY	SEE NOTE 1.1	0.12
D2003-011	T2003-011	33.31	32.38					2	2	TUBE ASSY	SEE NOTE 1.1	0.26
D2003-011A	T2003-011A	33.31	32.38					2	2	TUBE ASSY	SEE NOTE 1.1	0.26
D2003-013	T2003-013	12.7	13.54					2	2	TUBE ASSY	SEE NOTE 1.1	0.12
D2003-015	T2003-015	17.2	18.00					2	2	TUBE ASSY	SEE NOTE 1.1	0.14
D2003-017	T2003-017	17.0	16.25					2	2	TUBE ASSY	SEE NOTE 1.1	0.15
D2003-019	T2003-019	9.8	10.62			2	2			TUBE ASSY	SEE NOTE 1.2	0.15
D2003-021	T2003-021	N/A	2.25			2	2			TUBE ASSY	SEE NOTE 1.2	0.11
D2003-023	T2003-023	4.5	5.33			2	2			TUBE ASSY	SEE NOTE 1.2	0.10
D2003-025	T2003-025	9.8	10.60			2	2			TUBE ASSY	SEE NOTE 1.2	0.14
D2003-027	T2003-027	7.25	7.38			2	2			TUBE ASSY	SEE NOTE 1.2	0.12
D2003-029	T2003-029	17.2	18.00			2	2			TUBE ASSY	SEE NOTE 1.2	0.22
D2003-031	T2003-031	14.6	15.38	2	2					TUBE ASSY	SEE NOTE 1.3	0.59
D2003-033	T2003-033	29.75	29.62	2	2					TUBE ASSY	SEE NOTE 1.3	1.01
D2003-035	T2003-035	26.38	27.00	2	2					TUBE ASSY	SEE NOTE 1.3	0.93
D2003-037	T2003-037	24.81	24.81	2	2					TUBE ASSY	SEE NOTE 1.3	0.87
D2003-037A	T2003-037A	24.81	24.81	2	2					TUBE ASSY	SEE NOTE 1.3	0.87
D2003-039	T2003-039	34.0	34.00	2	2					TUBE ASSY	SEE NOTE 1.3	1.13
D2003-041	T2003-041	6.0	5.88	2	2					TUBE ASSY	SEE NOTE 1.3	0.22
D2003-043	T2003-043	11.7	10.75	2	2					TUBE ASSY	SEE NOTE 1.3	0.45
D2003-045	T2003-045	3.50	2.44	2	2					TUBE ASSY	SEE NOTE 1.3	0.21
D2003-047	T2003-047	5.56	5.56	2	2					TUBE ASSY	SEE NOTE 1.3	0.29
D2003-049	T2003-049	33.2	34.00	2	2					TUBE ASSY	SEE NOTE 1.3	1.13
D2003-077	T2003-077	N/A	6.25					1	1	JET	SEE NOTE 1.1	0.04
D2003-101	T2003-101	13.25	13.13					2	2	TUBE ASSY	SEE NOTE 1.1	0.12
D2003-103	T2003-103	12.38	12.00					2	2	TUBE ASSY	SEE NOTE 1.1	0.10
D2003-105	T2003-105	16.50	16.19					2	2	TUBE ASSY	SEE NOTE 1.1	0.14
D2003-107	T2003-107	12.75	12.25					2	2	TUBE ASSY	SEE NOTE 1.1	0.12
D2003-109	T2003-109	8.25	8.13					2	2	TUBE ASSY	SEE NOTE 1.2	0.12
D2003-111	T2003-111	4.75	4.63					2	2	TUBE ASSY	SEE NOTE 1.2	0.08
D2003-116	T2003-116	4.0	N/A							HEATSLEEVE	M2650-20 CRINKLE-SOFT	1.00
D2003-120	T2003-120	4.0	N/A							HEATSLEEVE	M2650-16 CRINKLE-SOFT	0.78
D2003-14	T2003-14	4.0	N/A							HEATSLEEVE	M2650-14 CRINKLE-SOFT	0.75
D2003-16	T2003-16	4.0	N/A							HEATSLEEVE	M2650-16 CRINKLE-SOFT	0.78
D2003-205	T2003-205	9.75	9.60					2	2	TUBE ASSY	SEE NOTE 1.1	0.10
D2003-207	T2003-207	3.75	3.75					2	2	TUBE ASSY	SEE NOTE 1.1	0.04

C	FORMAT TO CURRENT STD. UPDATE NOTES AND TABLE. REVISE D2003-035/-037/-105. ADD D2003-011A/-037A, AND MISSING DIMENSION. REASON: PART10-024.	MB	14.10.06
B	UPDATE PER TEMPLATES; ADD PIN'S; 0.025 TUBING NOW 0.035 (TSR1049)	CP	99.06.08
A	NEW ISSUE	JB	90.04.09
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	14.10.06		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2003	REV. C SHEET 1 OF 1
TITLE 206 CABIN HEATER TUBE ASSY	
SCALE NTS	
COPYRIGHT © 1990 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2014-10-20

TMF
132857

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>FF</u>	Audited by: <u>30</u> <u>9-89</u>	Preliminary Approval:
Date: <u>MAY 13 2015</u>	Date: <u>MAY 12 2015</u>	Date:

FORMS\Quality Assurance\approved QA\FAI revE